

Date: Monday, 3/17/2008 11:57:22 AM  
User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	AFT CROSSTUBE		
Job Number	38043		Part Number	D2890		
Estimate Number	10377		Drawing Number	D2890 REV B		
P.O. Number	:		Project Number	N/A		
This Issue	3/17/2008	S.O. No. :	Drawing Revision	B		
Prsht Rev.	NC		Material	:		
First Issue	/ /	Type : PURCHASED PARTS	Due Date	4/4/2008	Qty:	1 Um: Each
Previous Run	38042					
Written By	:	<i>Johnston 03/17</i>				
Checked & Approved By	:					
Comment	Est. D	05.03.21	Removed Bending procedures	KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6008180	Crosstube extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
	Qty	Part #	Description
1	D6008-180	Crosstube extrusion	Batch <i>B23964</i>
2.0	BENDING	BENDING MACHINE	
		Comment: BENDING MACHINE	<i>DP 8-4-3</i>
		1-Bend D2890 as per Dwg D2890 and Folio FT002	<i>DP 8-4-3</i>
3.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	<i>5 08/04/03</i>
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	<i>1-31. w/o 37951</i>
		1-Deburr and Polish	<i>a/15</i>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	<i>a/1</i>
		Chemical Conversion Coat as per QSI 005 4.1	<i>(</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 38043		Part Number: D2890
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
7.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>n/a</i>		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
8.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE <i>used on w/o 37851</i> <i>08/04/04</i>		
Job Completion 		<i>unf</i> <i>08-04-03</i> <i>W</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

38043

Description: Crosstube Aft

Part Number:

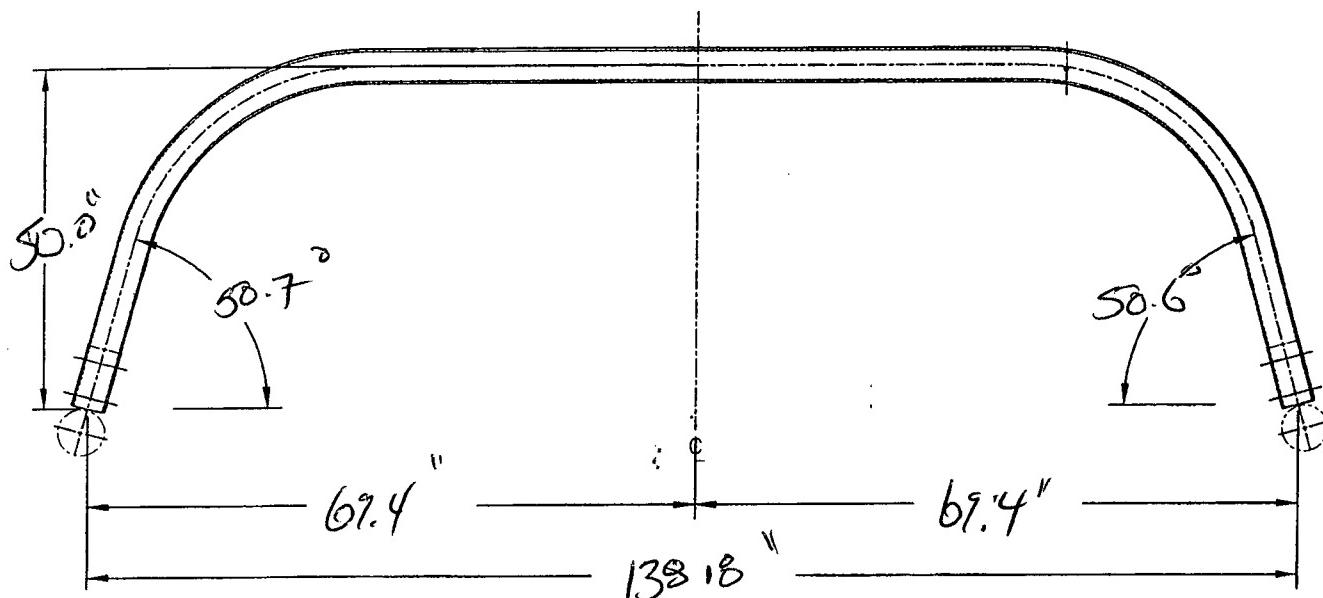
D2890

Inspection Dwg: D2890

Rev: B

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Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments

QC15 Inspection	<i>✓</i>
Date	<i>08/04/03</i>

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

**DART**

DESIGN	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED <i>#</i>	DRAWING NO. D2890
DATE		SHEET 1 OF 1
02.10.18		SCALE 1:20
A	99.05.21	NEW ISSUE
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES

**RELEASED**

02.10.28

